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CherryMAX® Rivet CR3212-5-04

CR3212-5-04 is a high-strength blind rivet from the CherryMAX® series with a 5/32" shank diameter and a 100° flush countersunk head. It features a mechanically locked stem that provides secure and permanent fastening in aerospace structures where only single-side access is available. Designed for medium grip range installations.

Basic Specifications

- Shank Diameter: 5/32 inch (≈0.156 inch)
- Grip Range: 0.188 – 0.250 inch
- Overall Length: 0.375 – 0.395 inch
- Head Diameter: ≈0.281 inch
- Head Height: ≈0.052 inch
- Head Style: 100° flush countersunk
- Sleeve — Aluminum alloy 5056, anodized or chromate coated
- Mandrel — Alloy steel 8740, cadmium plated
- Standards Compliance: NAS9302B, MS20600, MIL-SPEC (AS), BACR15FR5
- Manufacturer: Cherry Aerospace, USA.

Material Thickness Selection Guidelines

- Recommended for material stack thickness between 4.8 – 6.35 mm
- Use CR3212-5-03 or shorter variants for thinner assemblies
- Use CR3212-5-05 or longer variants for thicker applications
- Compatible with Cherry G747, G27, G704B, or equivalent pneumatic installation tools.

Part Identification and Marking Structure

- CR — CherryMAX series
- 32 — Rivet type
- 12 — 100° flush head configuration
- 5 — Nominal diameter 5/32 inch
- 04 — Length code for 0.188 – 0.250 inch grip range.

Key Features and Installation Characteristics

- Flush 100° countersunk head for smooth surface finish
- Recommended hole diameter: 0.161 – 0.164 inch
- Audible “click” confirms successful mechanical locking of the stem
- Stem remains fully retained — no mandrel protrusion
- Enables blind installation with access from one side only.

Coating and Visual Identification Notes

- Sleeve appearance: gold (chromate) or silver (clear anodized)
- Mandrel: cadmium-plated, silver-gray
- Common part markings: CR3212-5-04, AF3212-5-04, NAS9302B-5-04
- Color is not a reliable identifier — always confirm by part number.

Additional Technical Characteristics

- Shear Strength: up to 58,000 PSI
- Tensile Strength: up to 85,000 PSI
- Operating Temperature Range: -65°F to +250°F (-54°C to +121°C)
- Minimum Countersink Depth: 0.040 inch
- Head Seat Radius: 0.110 – 0.130 inch
- Installation Air Pressure: 90 psi nominal
- Typical Installation Time: ≤ 1.4 seconds.

Practical Notes from Technician

- Slight play before installation is acceptable
- Ensure hole diameter is within tolerance (0.161–0.164 inch)
- Do not use lubricants during installation
- Apply reduced force for composite structures to prevent delamination
- Installation tools must be properly maintained
- Minimum air pressure: 85 psi
- Click sound confirms full stem engagement
- Stem tail should be flush with sleeve within ±0.005 inch.

Note: This technical information is based on the official documentation provided by Cherry Aerospace and is intended solely for reference in product selection and specification.

